

Work Order ID 114539

\*114539\*

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Monday, March 10, 2014 1:01:46 PM

Item ID: D206-667-103 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Fwd High Crosstube 206L/L1/L3/L4

Start Date: 3/10/2014 Start Qty: 1.00 \*1\*

Required Date: 3/11/2014 Req'd Qty: 1.00 \*1\*

Reference: RMA RA111684

Cust Item ID: Customer: CGREA01

Approvals: Process Plan: MC Date: 14-3-10 Tooling: Date: Run Start \*NR1\*

QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-143	Rev C (DEO)								
DSI9565	A								
DSI9628	A								
100		0.00							
*100*									
QC	Memo	0.00							
Quality Control	INSPECT RA111684								
	D206-667-103 X 1 B107454								
	ADD D206-667-017 X 1 B <u>112920</u>								
	ID AND STOCK UNDER NEW BATCH NUMBER								
110		0.00							
*110*									
Crosstubes	Memo	0.00							
Crosstubes	ASSEMBLE D206-607-017 TO XTUBE								
	TOUCH UP IF NECESSARY								

1 0 0 AP  
14-3-14

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Item ID: D206-667-103 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Fwd High Crosstube 206L/L1/L3/L4  
Start Date: 3/10/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 3/11/2014 Req'd Qty: 1.00 **\*1\*** Customer: CGREA01  
Reference: RMA RA111684

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

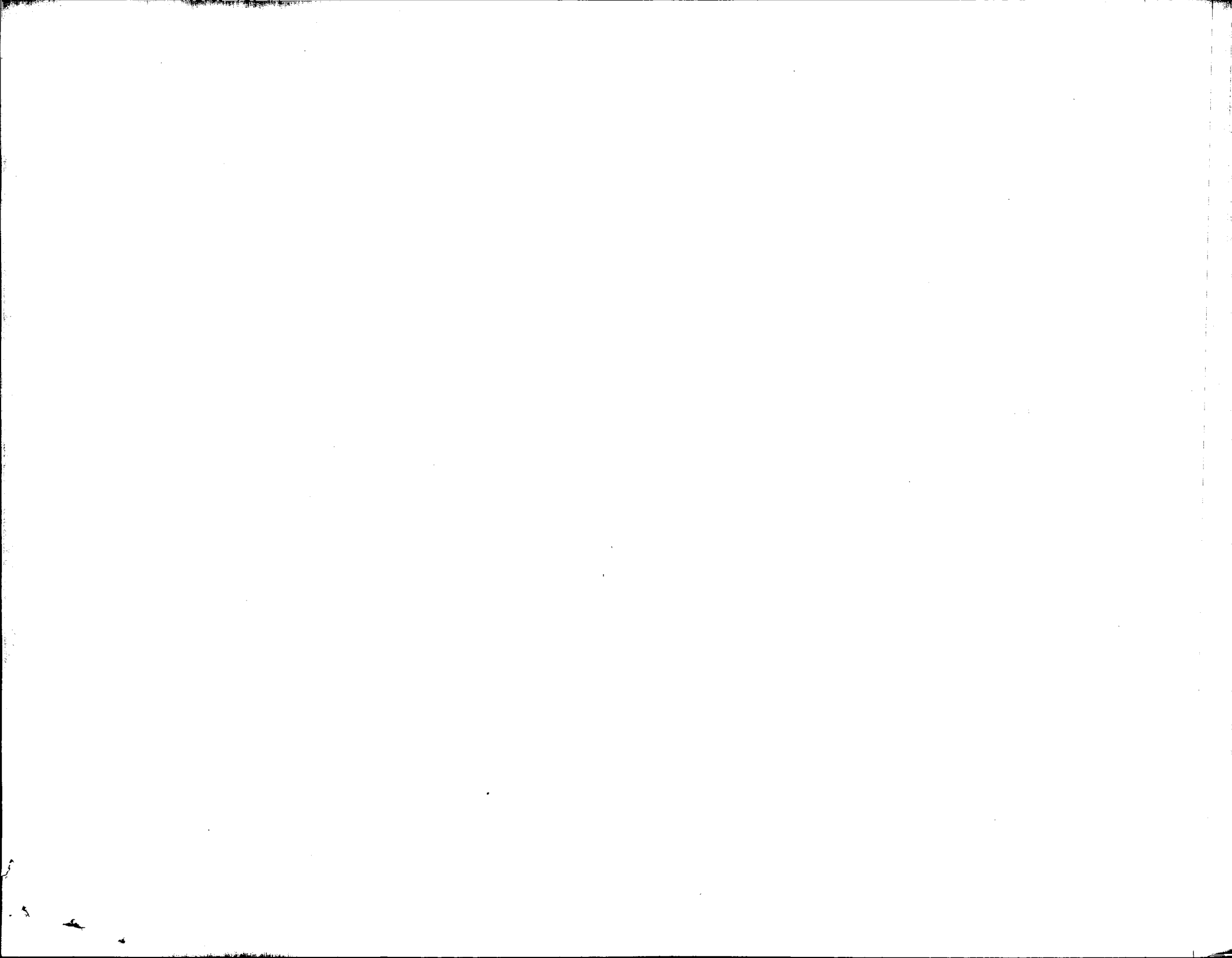
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				1			
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>094</u>  Memo	0.00 0.00							
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

DAS  
06  
9-89

MAR 20 2014

14-03-20

14-03-20



# Picklist Print

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Work Order ID: 114539

**\*114539\***

Parent Item: D206-667-103

**\*D206-667-103\***

Parent Item Name: Fwd High Crosstube 206L/L1/L3/L4

Start Date: 3/10/2014

Required Date: 3/11/2014

Start Qty: 1.00

Required Qty: 1.00

**Comments:**  
 IPP Rev:F 05.09.01 Add holes for compatibility with Bell SkidtubesKJ/JLM  
 IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:  
 IPP Rev: H 08.11.17 QC5 was QC6 at step 12 KJ verified by: EC  
 IPP Rev:I 08-12-15 add magnobond DD verified by:EC  
 IPP Rev J 09.01.06 ECN 08-562 EC verified by: DD  
 IPP Rev:K 09-01-19 as per DSI9439 DD verified by:EC IPP REV:L  
 11.08.05 PER ECN 11-615 DD VERF:EC IPP REV:M 12.08.20  
 DSI9628 revA (ECN12-631) DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-667-017

Manufactured No

Each 17.0000

1

**\*D206-667-017\***

**\*\***

*AS 14-3-13*

Ground Strap Installation

Location 112920

Loc Qty

Loc Code

①

FG

2

102581

2

108755

4

112272

4

LG050

7

107968

5

97504

2

D206-667-103

Manufactured No

Each 7.0000

1

**\*D206-667-103\***

**\*\***

Fwd High Crosstube 206L/L1/L3/L4

Location

Loc Qty

Loc Code

FG

6

100024

1

100030

1

100032

1

100034

1

100035

1

107453

1

FG113

1

112057

1

*1 x B107454  
MF  
14-3-10*

# **RA1116684 D206-667-103**

## **B107454**

RECEIVED FEBRUARY 18, 2014  
INSPECTED MARCH 6, 2014

CUSTOMER: GREAT SLAVE HELICOPTERS  
CONTACT: ALFONSO GARCIA  
SHIPPED FROM: CALGARY, ALBERTA, CANADA

### **Instructions for RA111684 D206-667-103 B107454**

- Kit complete
- Needs new labels & paper
- Assemble new D206-667-017 to cross tube as per DSI instructions
- Preform touch ups if needed
- Needs new work order

*chg 004*

**Time Estimate** = 2 HOURS

**Departments Required:** Cross tube assembly

**Pictures Attached** = N/A

**QTY INSPECTED** = x1 D206-667-103 B107454

**THIS INSTRUCTION SHEET MUST  
BE ATTACHED TO THE  
RESTOCKING WORK ORDER AT  
ALL TIMES!!!!**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		